

Work Order ID 61065

Thursday, August 05, 2010 10:13:10 AM



Page 1

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 8/5/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10-8-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4034	A

100 Weld per dwg A/R S.S. rod Batch: 111585 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

Cpl 10-10-20

110



QC

Quality Control

(Handwritten circle around QC9)

QC9- Inspect visual per QS1004- Fusion Welds 0.00

Memo

0.00

H 10-10-21

3

120



QC

Quality Control

(Handwritten checkmark)

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

3 10-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 61065

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Page 2

Item ID:	D4034-043	Accept		Setup	Start	
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Item Name:	Fwd Upper Rib Assembly				Stop	
Start Date:	8/5/2010	Start Qty:	3.00			
Required Date:	8/12/2010	Req'd Qty:	3.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i> Memo	0.00 0.00		<i>SAD</i> <i>10-11-02</i>		<i>3</i>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/11/03</i> <i>MF</i> <i>10-11-2</i>

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 05, 2010 10:13:14 AM

Page 1

Work Order ID: 61065

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 8/5/2010





Required Date: 8/12/2010


Start Qty: 3.00


Required Qty: 3.00


Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC


IPP Rev:B as


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 		Manufactured	No			100	Each	0.0000	1	3			
Rib													
D4034-5 		Manufactured	No			100	Each	0.0000	1	3			
Rib													
D2327-3 		Manufactured	No			100	Each	19.0000	1	3			
Spacer Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		19							
				58406		1							
				58974		1							
				60320		17							
D4021-7 		Manufactured	No			100	Each	1.0000	1	3			
Hoop													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				58039		1							


 B60804 → (3) Pl 10.10.20

 B60806 → (3) Pl 10.10.20

 Pl 10.10.20

 B62108 → (3)

 Pl 10.10.20

 B60803 → (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

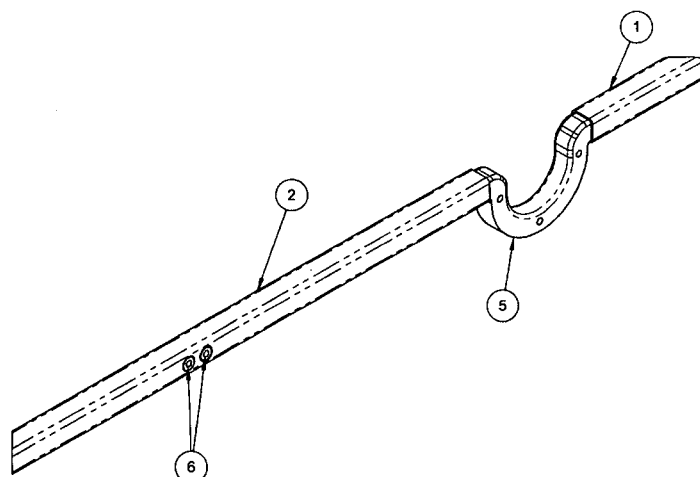
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

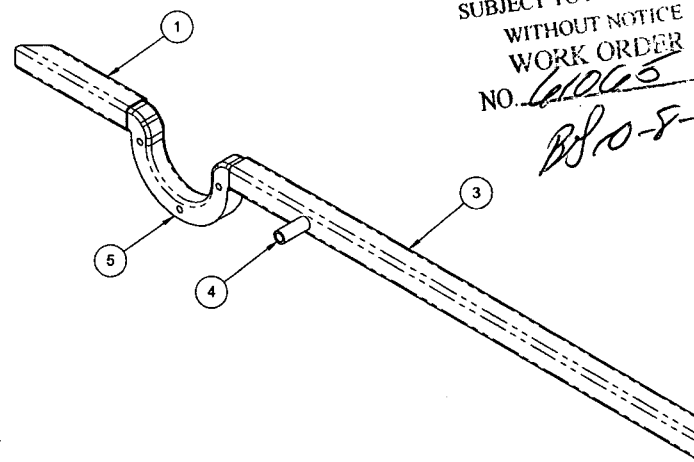
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *61065*
B/O-8-05

RELEASED
2010-03-12
MP

A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

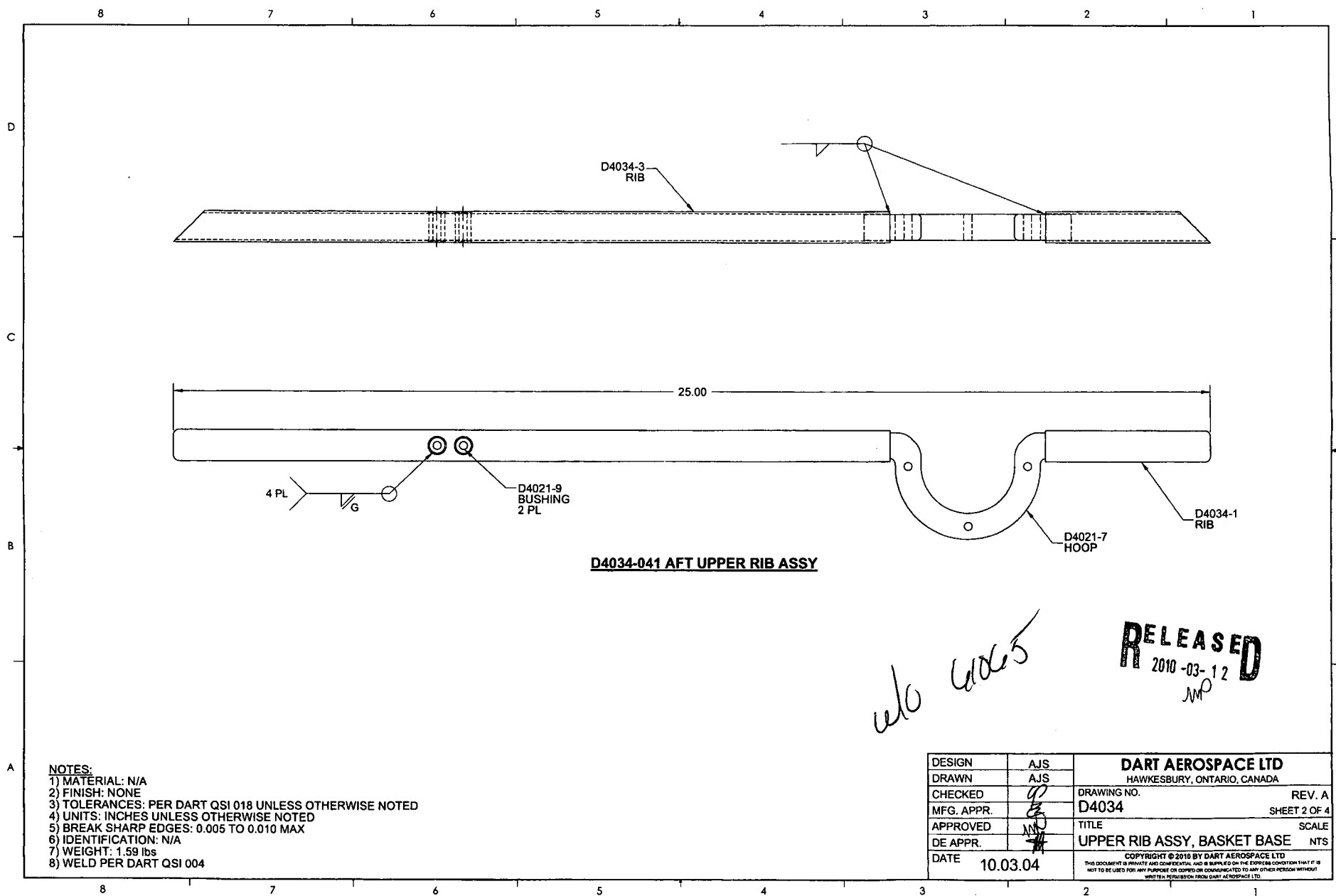
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4034-041 AFT UPPER RIB ASSY

wlc l0065

RELEASED
2010-03-12
JMO

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.59 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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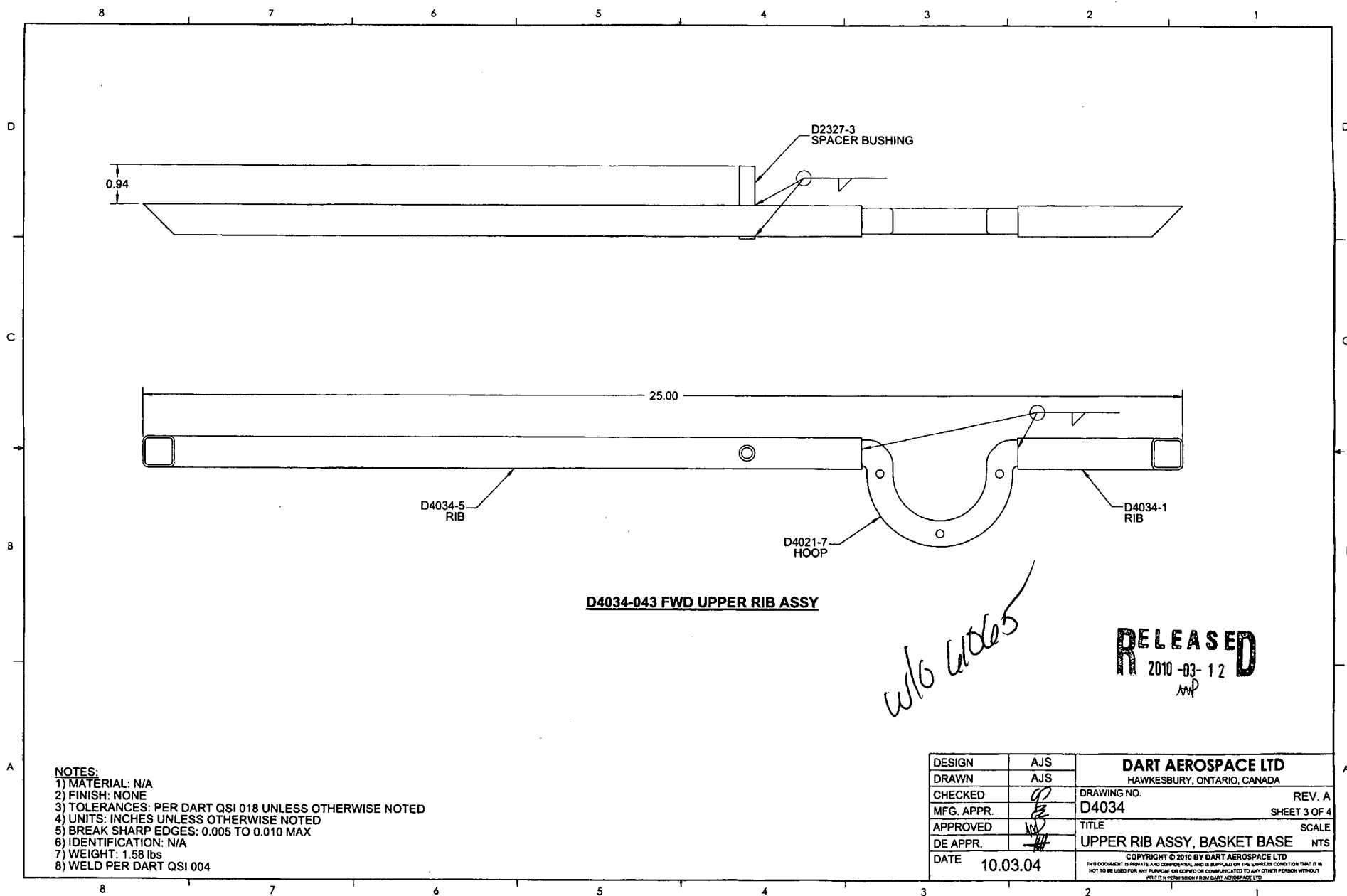
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



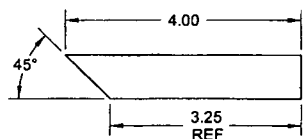
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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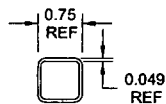
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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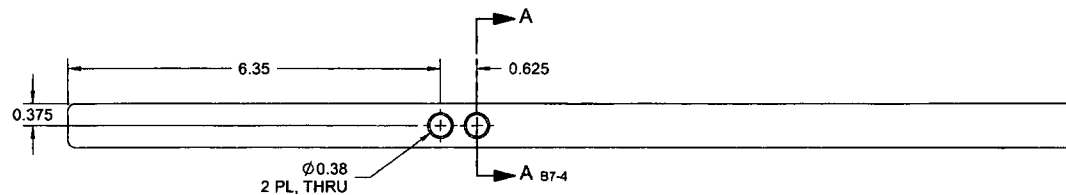
D4034-1 RIB



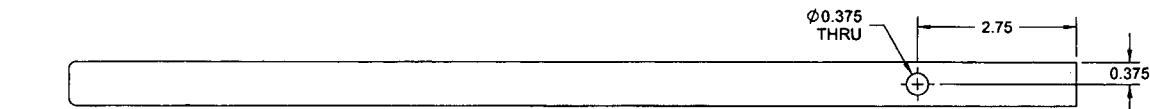
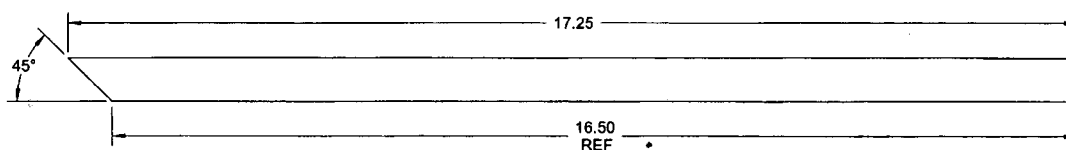
BREAK EDGE
0.030 X 45°
TYP



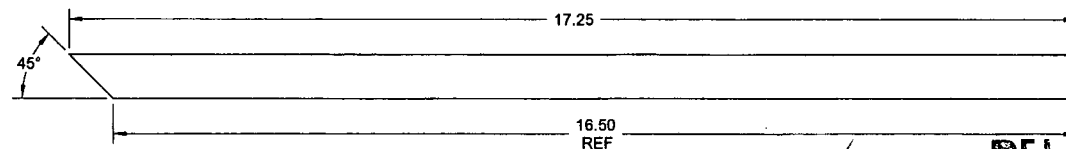
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 4 OF 4
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RELEASED
2010-03-12
MPT

who who 65

Dart Aerospace Ltd

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